

18/07/2008 1:20:04 PM

ecocq

Process Sheet

: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT ANGLE		
: 40666		Part Number	: D36981		
Estimate Number	: 13281	Drawing Number	: D3698 REV B		
P.O. Number	:	Project Number	: N/A		
This Issue	: 18/07/2008	S.O. No.		Drawing Revision	: B
Prsht Rev.	: NC	Material	:		
First Issue	: / /	Due Date	: 08/08/2008	Qty:	2 Um: Each
Previous Run	: 38877				
Written By					
Checked & Approved By	: <u>JUO 08 7.18</u>				
Comment	: Est Rev:A 08-04-25 new issue DD verified by:EC Est Rev:B 08-07-14 revB as per dwg DD verified by:ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S032	6061-T6 Sheet 0.032"	
		Comment: Qty.: 0.4700 sf(s)/Unit Total : 0.9400 sf(s) 6061T6 aluminium sheet .032" thick (M6061T6S032) Batch: <u>16954</u> <u>HB 8-7-24</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3698 Dwg Rev: <u>B</u> <u>HB 8-7-24</u> Prog Rev: <u>B</u> <u>(4)</u> ****grain direction along 1.378" ****	
		2- Deburr if necessary <u>HB 8-7-24</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>HB 8-7-24</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>S 08/07/24 (44)</u>	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		<u>(P2)</u>	
		Comment: NC BRAKE	
		1-Bend 105 deg. angle as per Dwg D3698	
		<u>SB 08/08/12</u>	
		<u>FF 08-08-14</u> <u>(2)</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3698-1 PAR #: N/A Fault Category: Sm. For NCR: Yes No DQA: JA Date: 08.08.22
 D3690-041 (D412-776-011) QA: N/C Closed: DD Date: 09/08/22

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/19	5.0	During forming they two parts were bent too much and when operator tries to re form the mat. cracked	10/08/19	Scrap and Destroy no replace alt ^(x2)	08/08/19 FF	✓ 08/08/19	10/08/19	08/08/19
		R.C. Parts were over bent.						

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SUPPORT ANGLE
Job Number: 40666		Part Number: D36981
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
2-form curve as per dwg D3698 and verify using template DT9001		
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 08/08/19 (X2)
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		 08-08-19 (2)
8.0	POWDER COATING	POWDER COATING  M102316
Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		 (2X)
START TIME: 8:50 AM		
OVEN TEMPERATURE: 320 °F		
FINISH TIME: 9:20		
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 BL 08/08/20
10.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST443		 08-08-20 (X2)
11.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 08/08/20 (X2)
Job Completion 		MF 08-08-21

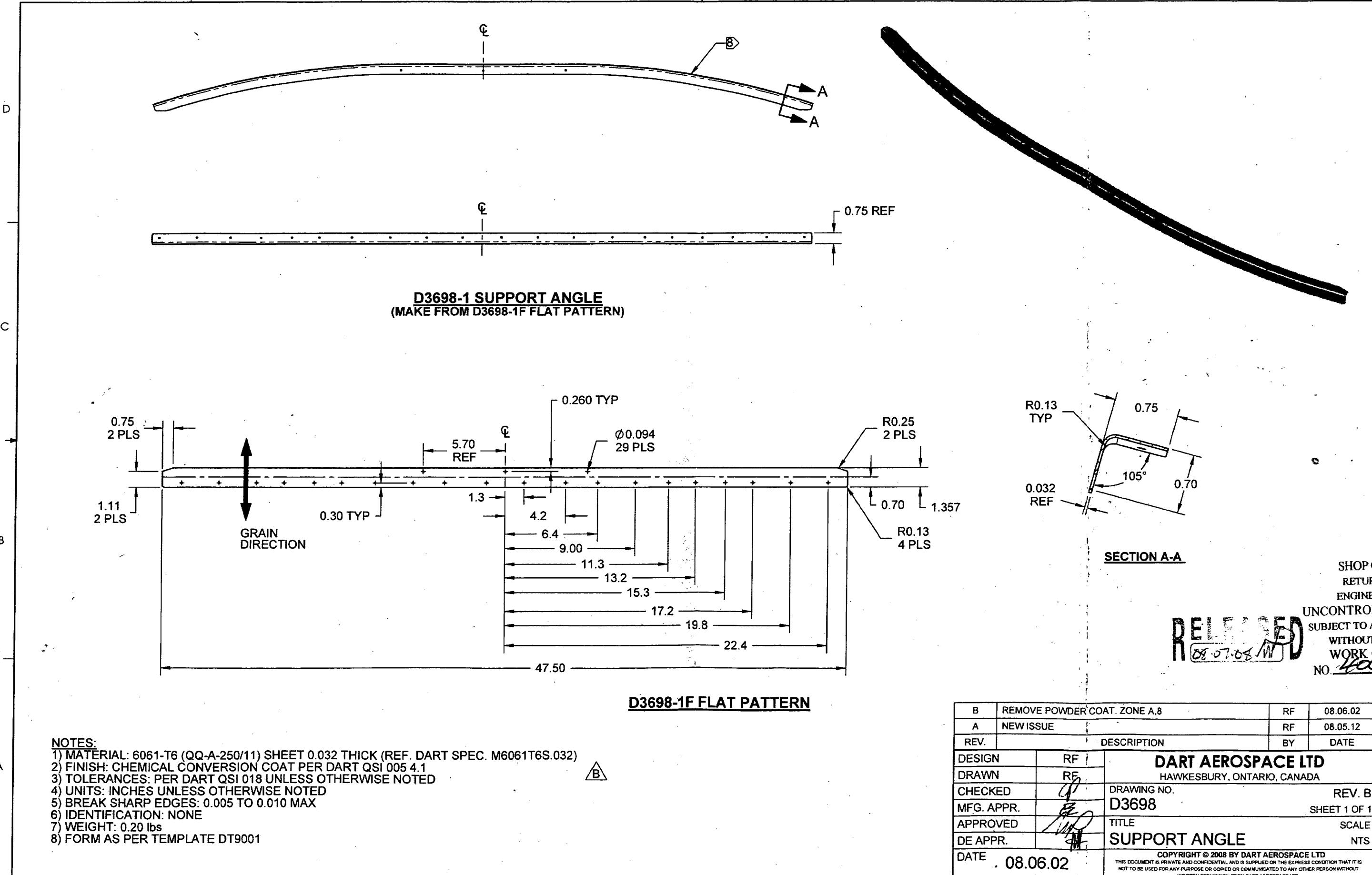
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

D

C

B

A

DART AEROSPACE LTD	Work Order:	40666
Description: SUPPORT ANGLE	Part Number:	D3698-1
Inspection Dwg: D3698-1 Rev: PRE.1.		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	FB	Audited by:	C	Prototype Approval:	1/1
Date:	8-7-24	Date:	08/07/24	Date:	1/1

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	